



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

*MUST SHIP
FEB 7*

D4854-1

Job Sheet 170769



Part No: D4854-1

Job Qty: 12 ea

Part Name: Lower Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 2/7/18

Type: SOLD

Description:

Note: D4854 REV:B IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS IPP REV:B 17.12.08 AS PER DWG REV:B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		2/6/18	0.00	0.00	Start Up Waterjet		<i>ac 18/01/29</i>
100	Waterjet	12 pcs		2/6/18	0.05	3.00	Waterjet1		<i>ac 18/01/29</i>
105	QC	12 pcs		2/6/18	0.00	0.00	QC2 Waterjet-1		<i>ac 18/01/29</i>
110	Mill Conv	12 pcs		2/6/18	0.00	11.01	Mill Conv 1		<i>J.C.-b. 18-02-02</i>
130	QC	12 pcs		2/6/18	0.00	0.00	QC8		<i>FK 18-2-7</i>
140	HandFinish	12 pcs		2/6/18	0.00	0.33	HandFinish1		<i>BR 18-2-8</i>
150	QC	12 pcs		2/6/18	0.00	0.00	QC7-4		<i>BR 18-2-8</i>
160	Powdercoat	12 pcs		2/7/18	0.00	0.60	Powdercoat1		<i>BR 18-2-8</i>
170	QC	12 pcs		2/7/18	0.00	0.00	QC3		<i>BR 18-2-8</i>
180	Packaging	12 pcs		2/7/18	0.00	0.00	Packaging3-2		<i>BR 18-2-8</i>
190	QC21-SA	12 Ea		2/7/18	0.00	0.00	QC21		<i>BR 18-2-8</i>

Part Op 100 - CUT AS PER FILE DWG REV: *B* PROG REV: *B* DEBURR

Descriptions: 110 - MILL RADS DRILL HOLES AS PER DWG USE DT10105 ,ORIENT FIXTURE WITH RED FACE ON SAME SIDE WHEN FLIPPING FIXTURE FROM SIDE TO SIDE OPEN SLOT TO .260" AS PER DWG DEBURR

160 ***MASK AS PER DWG*** START TIME: *9:00* OVEN TEMPERATURE: *320* FINISH TIME:

m 138467

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X04.000	6061-T6 Bar .750 X 4.00	4.9872 ft (.4156 ea)	90-Start up Operation	

FM127797

3.1 €

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

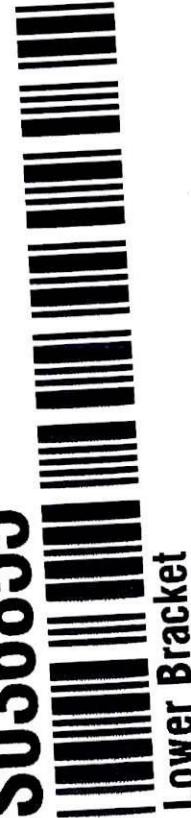
Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

☐ Pressure/Forced
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Wave/Twist in Tube
☐ Marks/Chatter

☐ Temp
☐ Set-up
☐ BOM/
☐ Broke
☐ Inspec
☐ Contai
☐ Count
☐ Cut Too Short
☐ Instructions Incomplete/Unclear
☐ Drill Holes

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART
AEROSPACE
S036855



Lower Bracket

D4854-1
PART NO:
Original Serial #: S036855
Revision:
Operation:
Change No:

Start up Operation 01/30/18
Job No: 170769



Engineering	☐
Quality	☐
Other	☐

MRB (QSI042) Approval

Completed By
Lead hand / Supervisor Approval Verification
QC / QA Coordinator Approval

Positioned Wrong	☐
Outside Dimensions	☐
Over/Under tolerance	☐
Part Incorrect	☐
Part Lost/Missing	☐
Part Moved	☐
Drawing	☐
Finish	☐
Misread	☐
Turning Sequence	☐

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
✓ 1	Lower Bracket	0.300Inches ± 0.030	0.330 0.270		
✓ 2	Lower Bracket	0.500Inches ± 0.030	0.530 0.470		
✓ 3	Lower Bracket	0.750Inches ± 0.030	0.780 0.720		
4	Lower Bracket	0.260Inches ± 0.005	0.265 0.255		
5	Lower Bracket	3.500Inches ± 0.030	3.530 3.470		
6	Lower Bracket	2.200Inches ± 0.030	2.230 2.170		
7	Lower Bracket	4.450Inches ± 0.030	4.480 4.420		
8	Lower Bracket	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
9	Lower Bracket	3.700Inches ± 0.005	3.705 3.695		
10	Lower Bracket	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
11	Lower Bracket	1.880Inches ± 0.030	1.910 1.850		
12	Lower Bracket	1.250Inches ± 0.010	1.260 1.240		
13	Lower Bracket	0.380Inches ± 0.030	0.410 0.350	Radius	
14	Lower Bracket	0.380Inches ± 0.030	0.410 0.350	Radius	

Plex 1/19/18 10:49 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Description Work Order Deviation				Disposition																																																													
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																